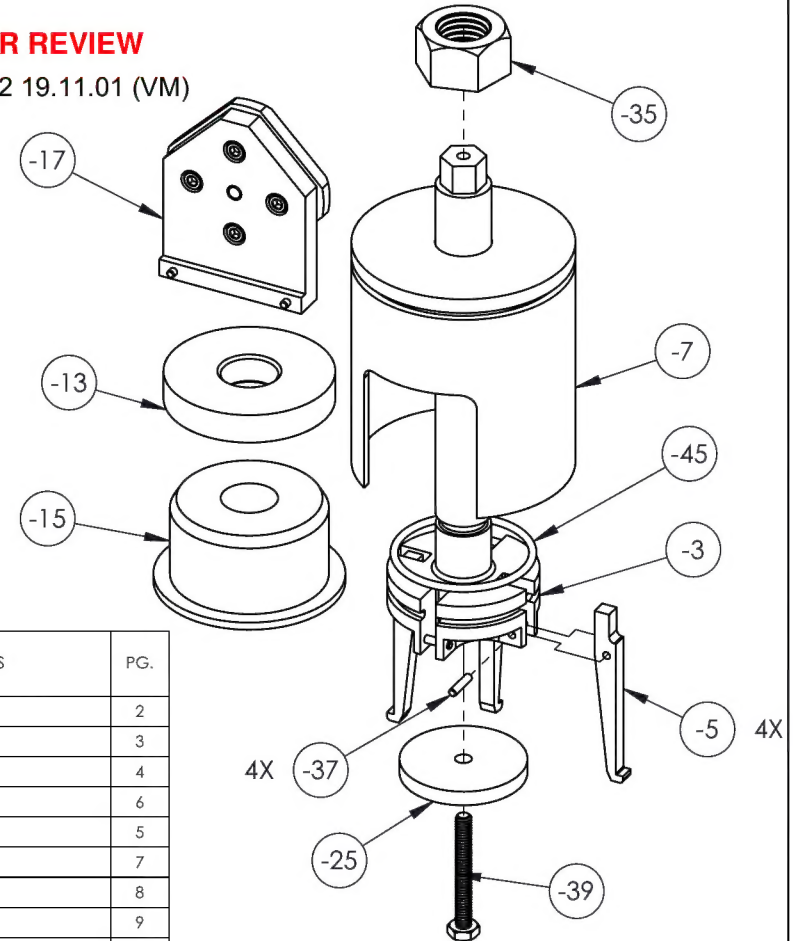
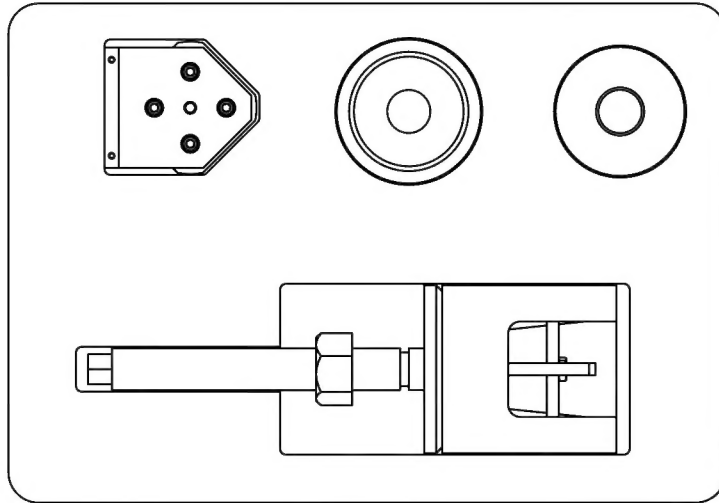


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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED

UNDER REVIEW

URF 19-1192 19.11.01 (VM)



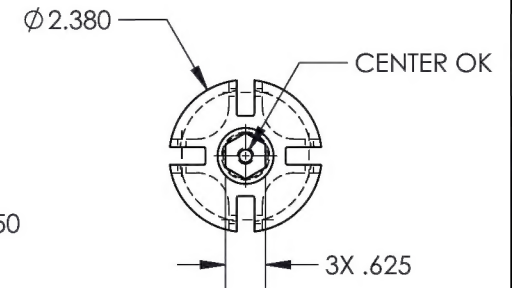
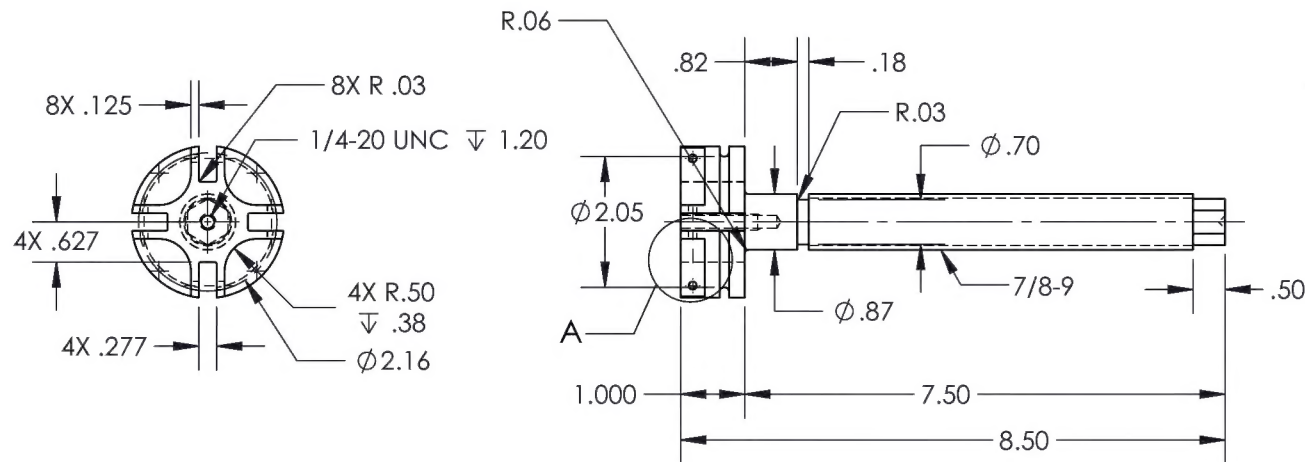
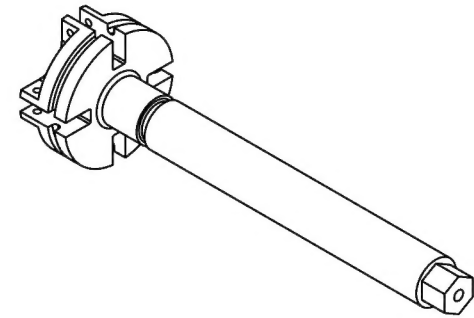
ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-3	1	PULLER BASE	4140	Ø2-1/2 X 8-5/8	2
			-5	4	LEG	S-7	1/4 X 1/2 X 3-1/8	3
	X		-7	1	PIPE WELDMENT			4
	1		-9		CAP	1018	Ø3-1/2 X 5/8	6
	1		-11		PIPE	DOM	Ø3-1/2 X 1/8 WALL X 3-3/4	5
			-13	1	RING	1018	Ø2-3/4 X 1/2	7
			-15	1	FLANGED RING	1018	Ø3 X 1-5/8	8
X			-17	1	TOOL ASSEMBLY			9
1			-19		PLATE	1018	1/4 X 2-3/8 X 2-3/8	11
1			-21		BASE	1018	5/8 X 2-5/8 X 3-3/16	10
4			-23		SCREW	STEEL	10-32 X 1/2 MCMaster-CARR #92562A416(MODIFIED)	12
			-25	1	BUSHING	1018	Ø2 X 1/4	13
			-27	1	BOTTOM FOAM	Y20 BLACK	4.29 X 10.40 X 14.94	14
			-29	1	TOP FOAM	Y20 BLACK	1.79 X 10.28 X 14.69	15
1		B/O	-31		DOWEL PIN	S.S.	Ø1/4 X 3/4 MCMaster-CARR #97395A485	9
2		B/O	-33		DOWEL PIN	S.S.	Ø1/8 X 5/8 MCMaster-CARR #97395A445	9
		B/O	-35	1	NUT	STEEL	7/8-9 MCMaster-CARR #94895A842	1
		B/O	-37	4	DOWEL PIN	STEEL	Ø1/8 X 9/16 MCMaster-CARR #98381A220	1
		B/O	-39	1	SCREW	STEEL	1/4-20 X 2 MCMaster-CARR #92620A550	1
		B/O	-41	1	CASE	PLASTIC	PELICAN CASE #APP-1450-E	NS
		B/O	-43	1	RED BARN PLACARD	ALUMINUM	RB41009 ATTACH TO OUTSIDE OF CASE	NS
		B/O	-45	1	O-RING	BUNA-N	3mm X 46mm ID MCMaster-CARR #9262K549	1
ASSY -17	ASSY -7							

REF: SIKORSKY P/N 76700-20014-047.

RED BARN MACHINE	
BIFILAR TOOL	
TITLE	
DWG NO. RBS76700-20014-047	
REV	
MAT'L	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
APPROVED <i>D Weil</i>	
HEAT TREAT	
FINISH	
SPEC	
USED ON MODEL	
S76	
SCALE 1:3	DATE 3/25/2013
SHEET 1 OF 15	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED



UNDER REVIEW

URF 19-1192 19.11.01 (VM)

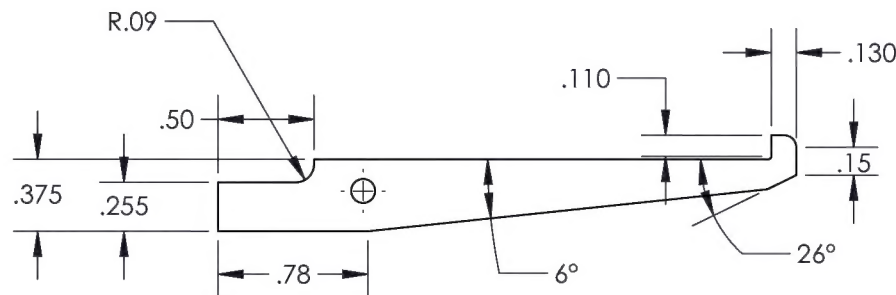
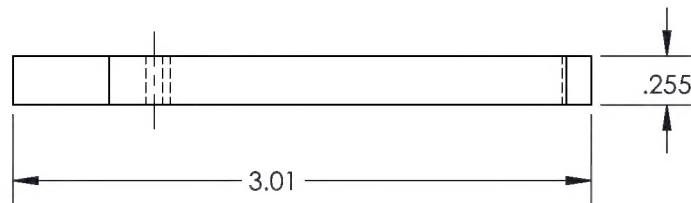
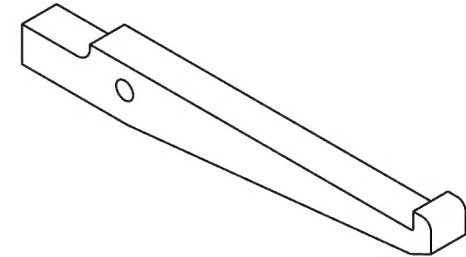
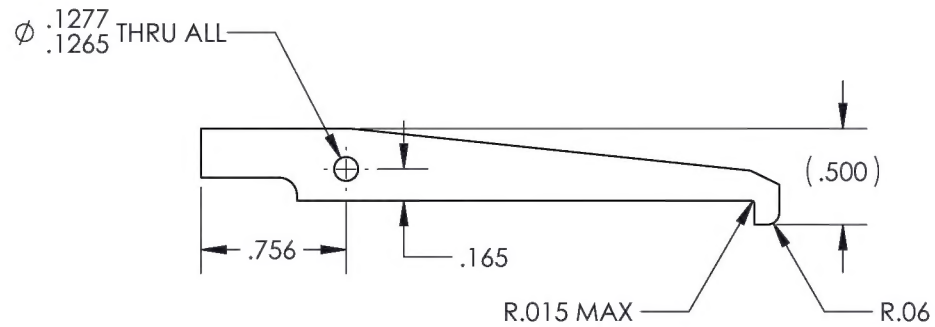
DETAIL A
SCALE 2 : 3

(-3)
PULLER BASE

RED BARN MACHINE	
TITLE BIFILAR TOOL	
DWG NO. RBS76700-20014-047-3	REV
MAT'L 4140	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX \pm .005	HEAT TREAT
.XX \pm .01	FINISH BLACK OXIDE
.X \pm .1	ANGLES \pm 5°
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL S76
SCALE 1:3	DATE 3/25/2013
SHEET 2 OF 15	

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REV	DESCRIPTION	DATE	INITIAL	APPROVED



(-5)

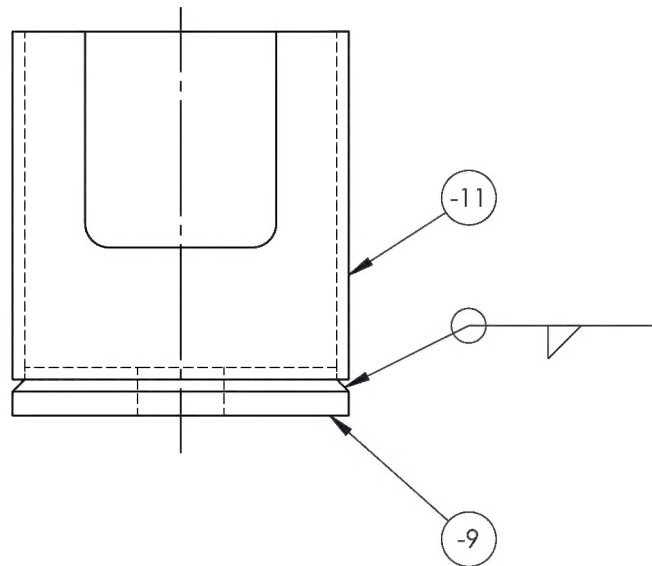
LEG

UNDER REVIEW
URF 19-1192 19.11.01 (VM)

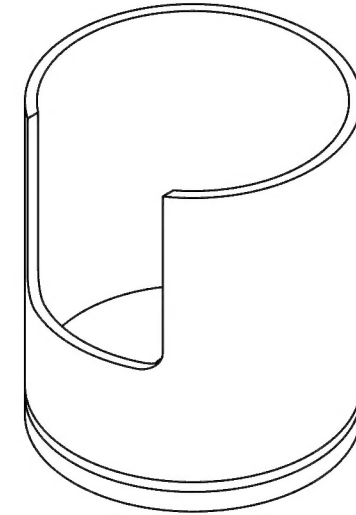
RED BARN MACHINE	
PULLER ASSY	
DWG NO.	RBS76700-20014-047-5
MAT'L S-7	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005	HEAT TREAT
.XX ± .01	FINISH BLACK OXIDE
.X ± .1	SPEC HRC 45-48
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	S76
SCALE 1:1	DATE 3/25/2013
SHEET 3 OF 15	

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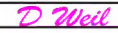
REVISONS			
REV	DESCRIPTION	DATE	INITIAL



(-7)
PIPE WELDMENT

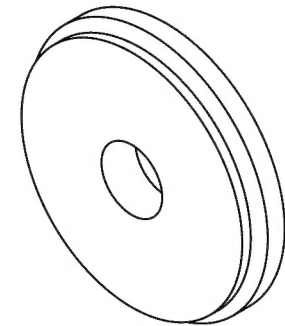
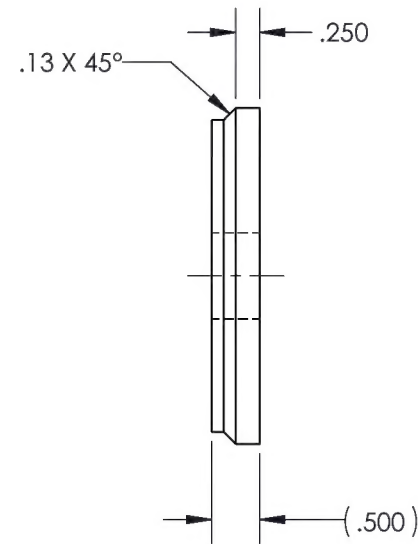
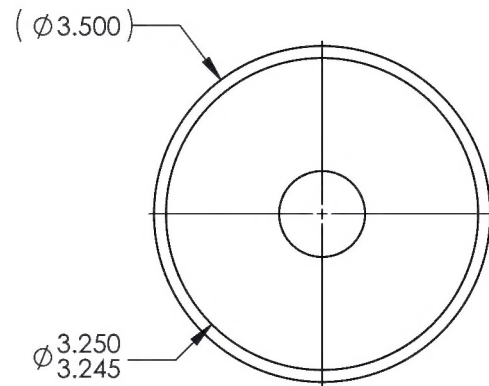


UNDER REVIEW
URF 19-1192 19.11.01 (VM)

 RED BARN MACHINE	
TITLE BIFILAR TOOL	
DWG NO. RBS76700-20014-047-7	REV
MAT'L 	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	APPROVED  HEAT TREAT FINISH BLACK OXIDE SPEC USED ON MODEL S76
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 3/25/2013
SHEET 4 OF 15	

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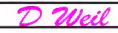
REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED



UNDER REVIEW

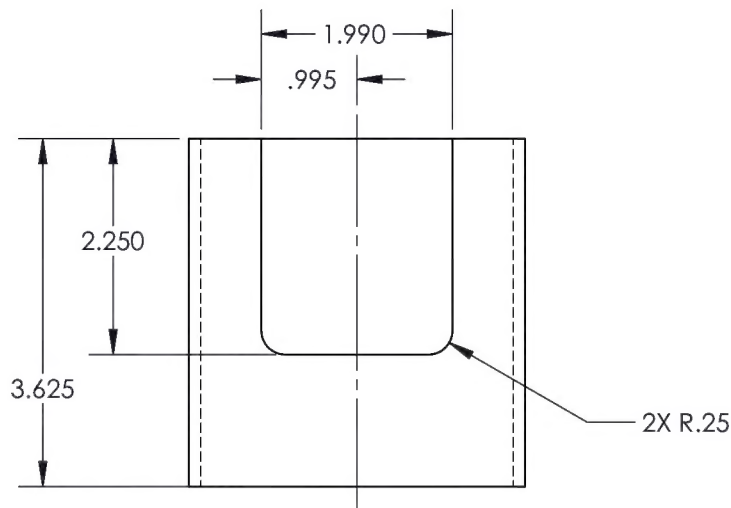
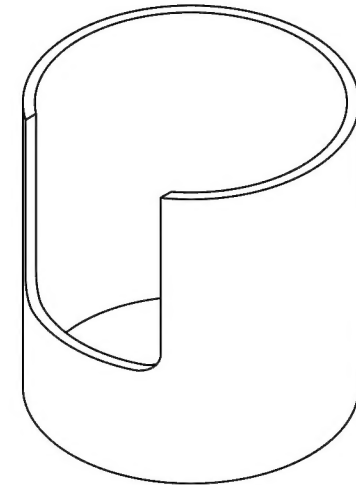
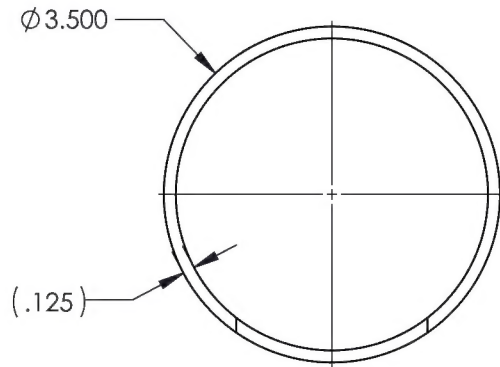
URF 19-1192 19.11.01 (VM)

⑨
CAP

 RED BARN MACHINE	
TITLE BIFILAR TOOL	
DWG NO. RBS76700-20014-047-9	REV
MAT'L 1018	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1	APPROVED  HEAT TREAT SEE -7 WELDMENT SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL S76
SCALE 1:2	DATE 3/28/2013
SHEET 5 OF 15	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED


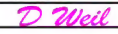


(-11)

PIPE

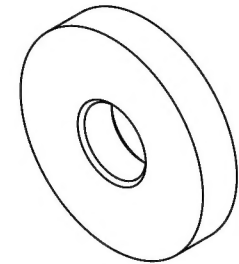
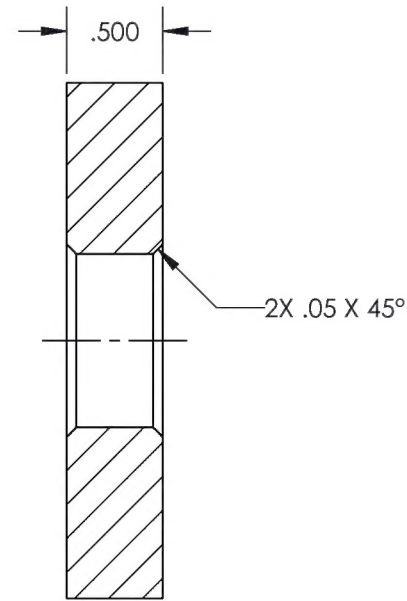
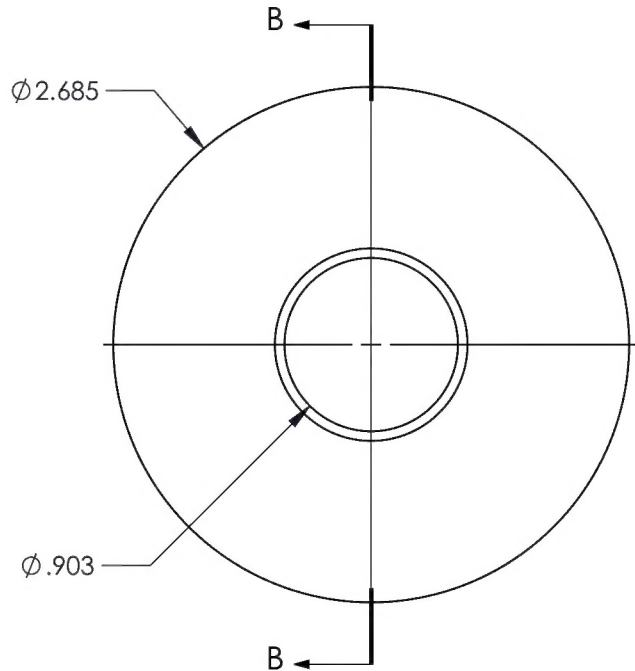
UNDER REVIEW

URF 19-1192 19.11.01 (VM)

 RED BARN MACHINE	
TITLE BIFILAR TOOL	
DWG NO. RBS76700-20014-047-11	REV
MAT'L DOM	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	APPROVED  HEAT TREAT SEE -7 WELDMENT SPEC USED ON MODEL S76
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 3/22/2013
SHEET 6 OF 15	

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REV	DESCRIPTION	DATE	INITIAL	APPROVED





SECTION B-B
SCALE 1 : 1

UNDER REVIEW
URF 19-1192 19.11.01 (VM)

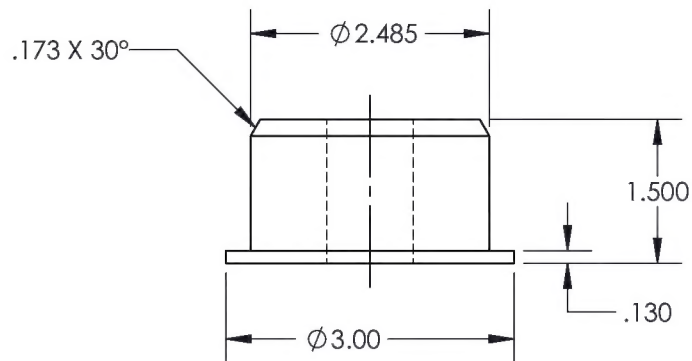
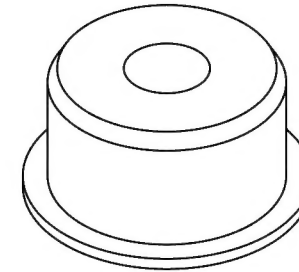
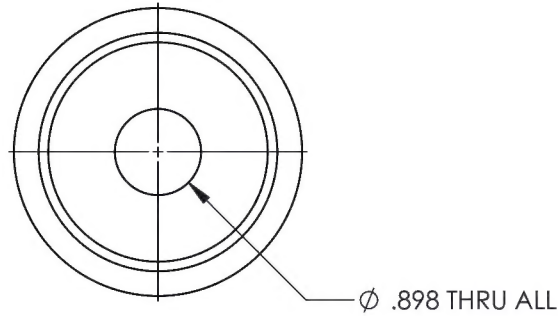
(-13)

RING

 RED BARN MACHINE	
TITLE BIFILAR TOOL	
DWG NO. RBS76700-20014-047-13	REV
MAT'L 1018	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX \pm .005 .XX \pm .01 .X \pm .1 FRACTIONS \pm 1/32 ANGLES \pm 5°	APPROVED  HEAT TREAT FINISH BLACK OXIDE SPEC USED ON MODEL S76
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 3/22/2013
SHEET 7 OF 15	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED


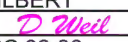


(-15)

FLANGED RING

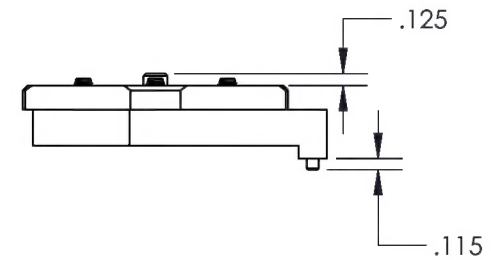
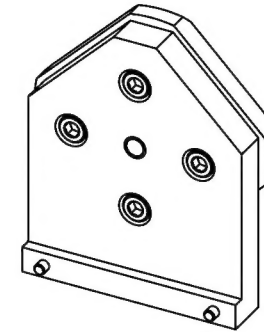
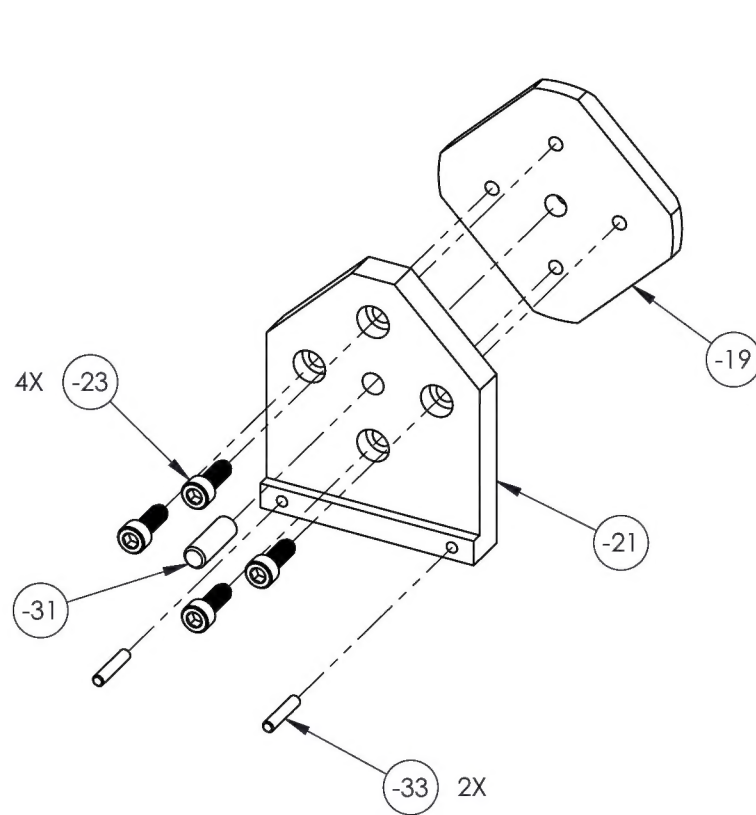
UNDER REVIEW

URF 19-1192 19.11.01 (VM)

 RED BARN MACHINE	
TITLE BIFILAR TOOL	
DWG NO. RBS76700-20014-110-15	REV
MAT'L 1018	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	APPROVED  HEAT TREAT HRC 32-36 FINISH BLACK OXIDE SPEC 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING
USED ON MODEL S76	
SCALE 1:2	DATE 3/22/2013
SHEET 8 OF 15	

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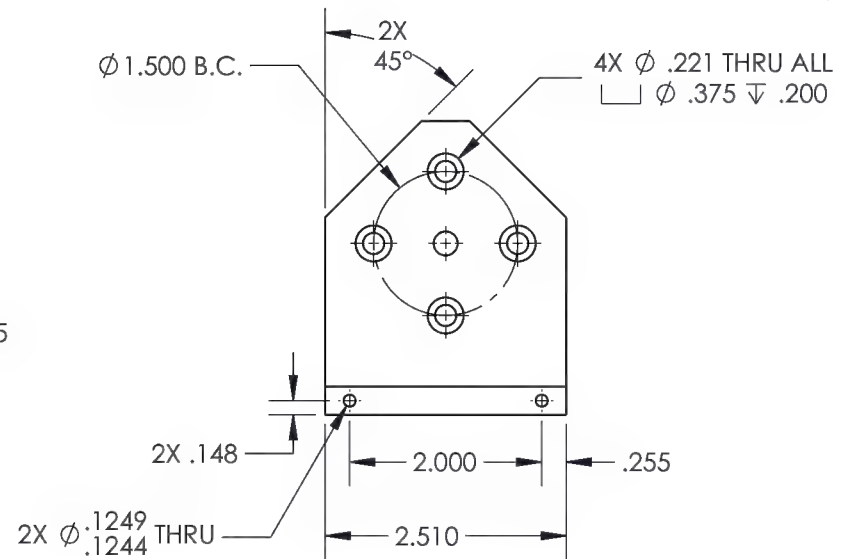
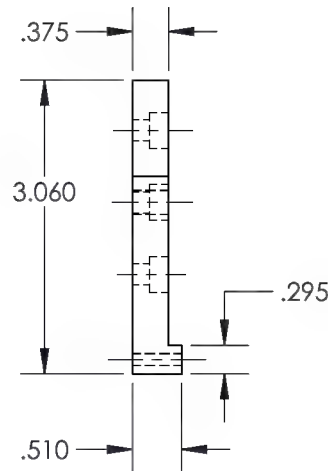
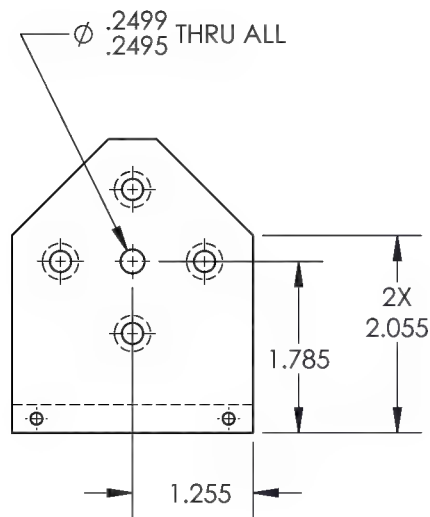
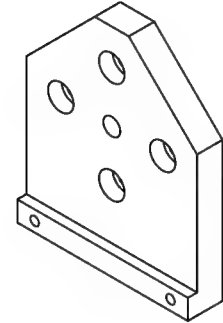
URF 19-1192 19.11.01 (VM)

(-17)
TOOL ASSEMBLY

 RED BARN MACHINE	
TITLE BIFILAR TOOL	
DWG NO. RBS76700-20014-047-17	REV
MAT'L	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1	APPROVED 
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	HEAT TREAT FINISH SPEC USED ON MODEL S76
SCALE 1:2	DATE 4/2/2013
SHEET 9 OF 15	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED



(-21)
BASE

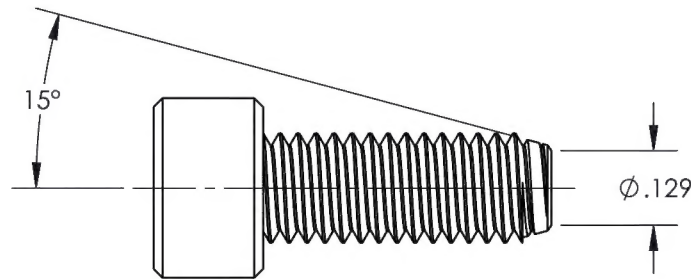
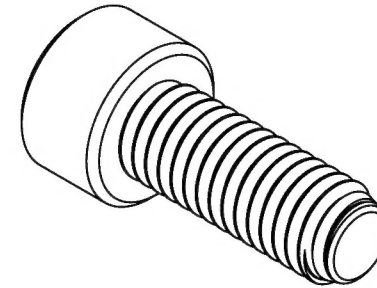
UNDER REVIEW

URF 19-1192 19.11.01 (VM)

 RED BARN MACHINE	
TITLE BIFILAR TOOL	
DWG NO. RBS76700-20014-107-21	REV
MAT'L 1018	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm .005$.XX $\pm .01$.X $\pm .1$ FRACTIONS $\pm 1/32$ ANGLES $\pm 5^\circ$	APPROVED  HEAT TREAT FINISH BLACK OXIDE SPEC USED ON MODEL S76
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 4/2/2013
SHEET 11 OF 15	

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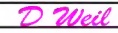
REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED



UNDER REVIEW

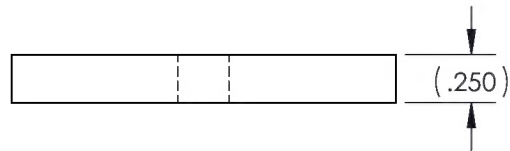
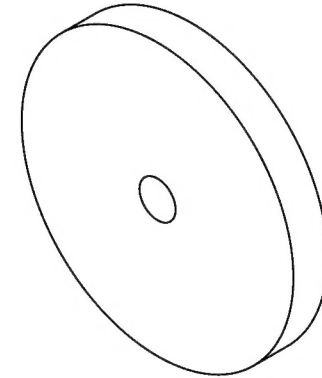
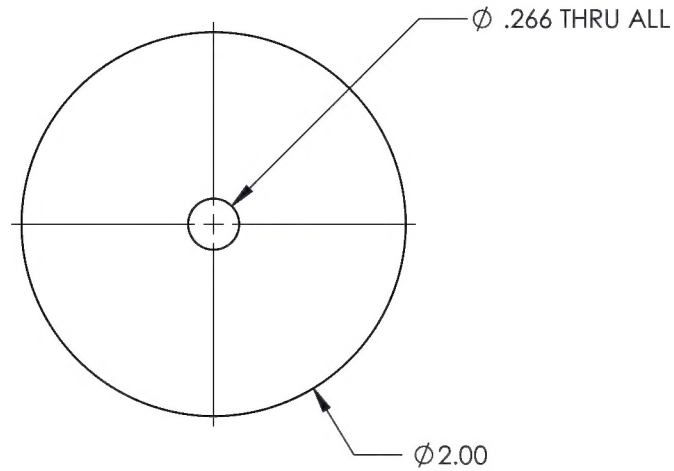
URF 19-1192 19.11.01 (VM)

(-23)
SCREW

 RED BARN MACHINE	
TITLE BIFILAR TOOL	
DWG NO. RBS76700-20014-107-23	REV
MAT'L STEEL	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1	APPROVED 
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	HEAT TREAT FINISH SPEC USED ON MODEL S76
SCALE 3:1	DATE 4/2/2013 SHEET 12 OF 15

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED


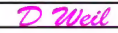


(-25)

BUSHING

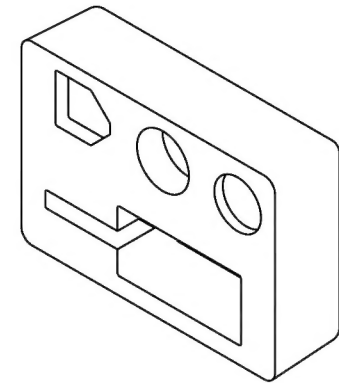
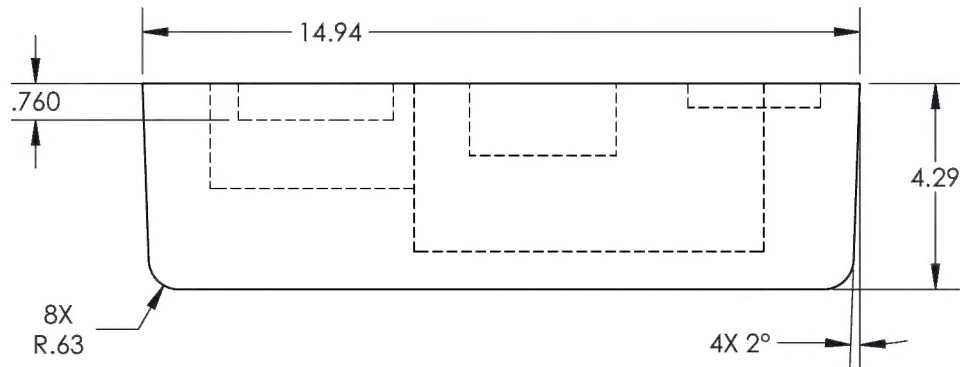
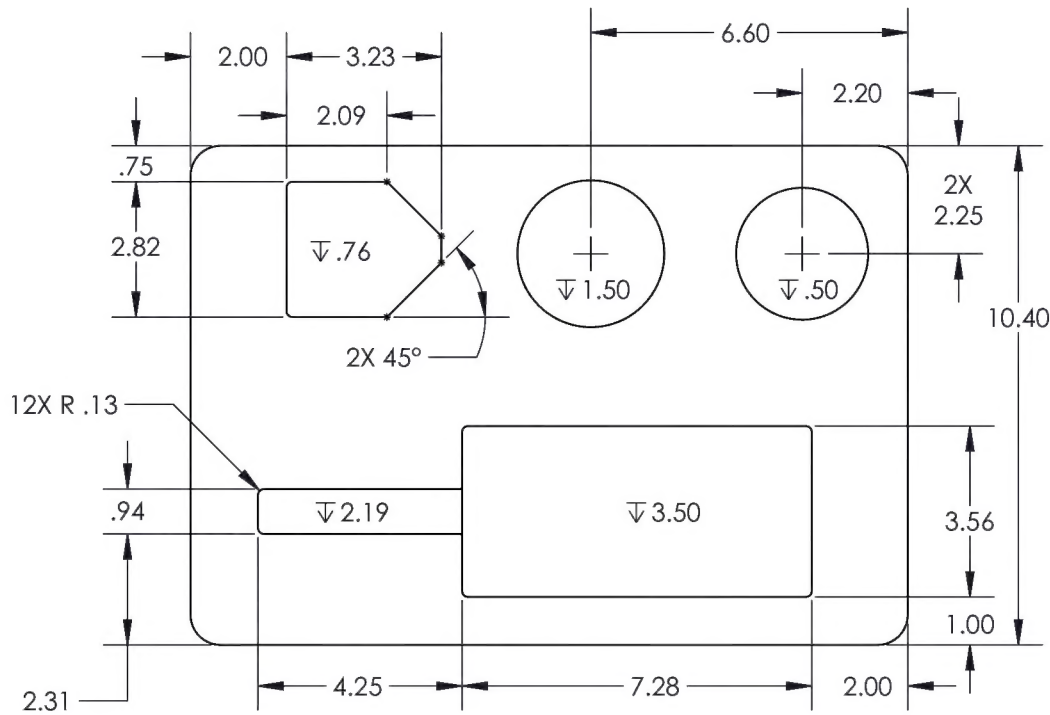
UNDER REVIEW

URF 19-1192 19.11.01 (VM)

 RED BARN MACHINE	
TITLE BIFILAR TOOL	
DWG NO. RBS76700-20014-047-25	REV
MAT'L 1018	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1	APPROVED 
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	HEAT TREAT FINISH BLACK OXIDE SPEC USED ON MODEL S76
SCALE 1:1	DATE 4/16/2013
SHEET 13 OF 15	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED



-27

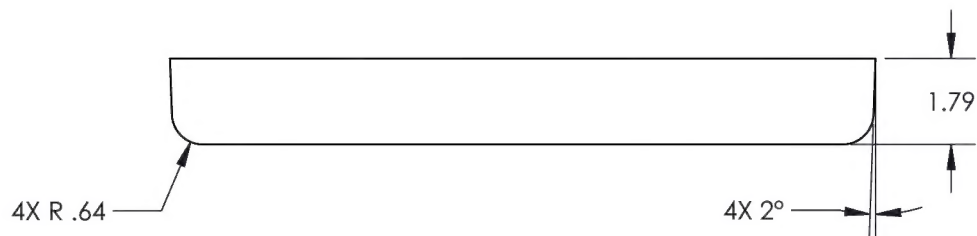
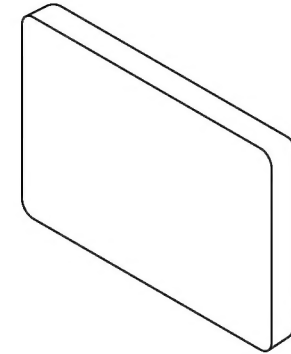
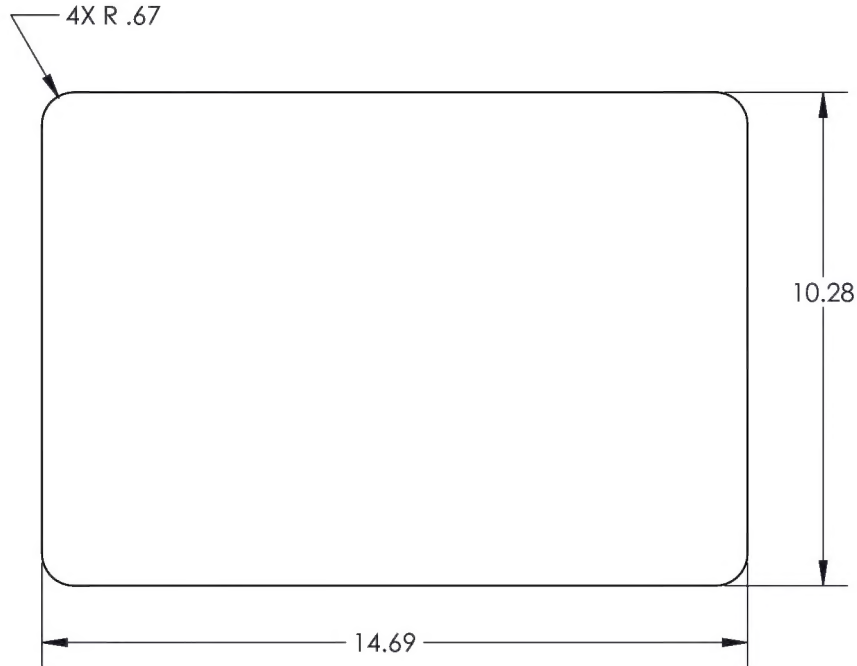
UNDER REVIEW

BOTTOM FOAM URF 19-1192 19.11.01 (VM)

RED BARN MACHINE	
TITLE BIFILAR TOOL	
DWG NO. RBS76700-20014-107-27	REV
MAT'L Y20 BLACK	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005	HEAT TREAT
.XX ± .01	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	S76
SCALE 1:4	DATE 4/2/2013
SHEET 14 OF 15	


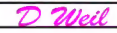
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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED



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TOP FOAM

UNDER REVIEW
URF 19-1192 19.11.01 (VM)

 RED BARN MACHINE	
TITLE BIFILAR TOOL	
DWG NO. RBS76700-20014-107-29	REV
MAT'L Y20 BLACK	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1	APPROVED  HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL S76
SCALE 1:4	DATE 4/2/2013
SHEET 15 OF 15	